

Fire Red

Dart Aerospace Ltd.

Date: Tuesday, 03/03/2009 4:12:17 PM  
 User: Julie Dawson

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SLIDING PLATE
Job Number : 46254	
Estimate Number : 11215	
P.O. Number :	Part Number : D33333
This Issue : 03/03/2009 S.O. No. :	Drawing Number : D3333 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : / /	Drawing Revision : B
Previous Run : 45082	Material :
	Due Date : 30/03/2009
Written By :	Qty: 10 Um: Each
Checked & Approved By : <u>JUD 09.03.04</u>	
Comment : Est. A05.01.13 New issue KJ/JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M1010B4000X00500	1010-1025 Steel Bar 4.00 x .500
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Comment: Qty.: 0.7984 f(s)/Unit Total: 4.7905 f(s)  
 AISI 1010-1025 Steel Bar  
 Material: AISI 1010-1025 or ASTM A36/A366/A569/A570 Cold Rolled Steel  
 (M1010-B4.000x00.500)  
 Identify for D3333-3  
 Batch: M110740

J.L 09/03/08

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW  
 Cut blanks: 4.000" x 0.500" thick x 9.620" long

J.L 09/03/08

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1  
 Machine as per Folio FA483 and Dwg D3333  
 Identify as D3333-3

(10)

J.L 09/03/09

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.L 09/03/09

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

J.L 09/03/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 03/03/2009 4:12:17 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SLIDING PLATE

Job Number: 46254

Part Number: D3333

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



(X10)

Comment: LARGE FABRICATION RESOURCE 1

09-03-23

Deburr and Grind 45° chamfer on opposite side of pocket along edges as per Dwg D3333

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

02/03/03

(X10)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

M102391

Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3

Ensure to mask threaded holes and sides

START TIME:

12:45pm

OVEN TEMPERATURE:

320°C

FINISH TIME:

1:15pm

09-04-16

(X10)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-04-16

(10)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

Cart

9/4/17

(10X)

SP

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/22

Job Completion



C209/04/17

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 40254
<b>Description:</b> Sliding Plate		<b>Part Number:</b> D3333-3
<b>Inspection Dwg:</b> D3333	<b>Rev:</b> B	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.900	+/-0.010	3.901	✓			
9.50	+/-0.030	9.501	✓			
0.650	+/-0.010	.649	✓			
2.310	+/-0.010	2.311	✓			
1.125	+/-0.010	1.126	✓			
1.950	+/-0.010	1.950	✓			
1.200	+/-0.010	1.200	✓			
1.300	+/-0.005	1.300	✓			
R0.125	+/-0.010	.125	✓			
0.500	+/-0.010	.494	✓			
0.440	+/-0.010	.339	✓			
1.675	+/-0.010	1.674	✓			
0.035 x 45°	+/-0.010 x 0.5°	.033x45°	✓			
0.485	+0.000/-0.010	.479	✓			
1.11	+/-0.030	1.112	✓			
3/8 - 24 UNF	N/A	3/8-24unf	✓			
0.450	+/-0.010	.445	✓			

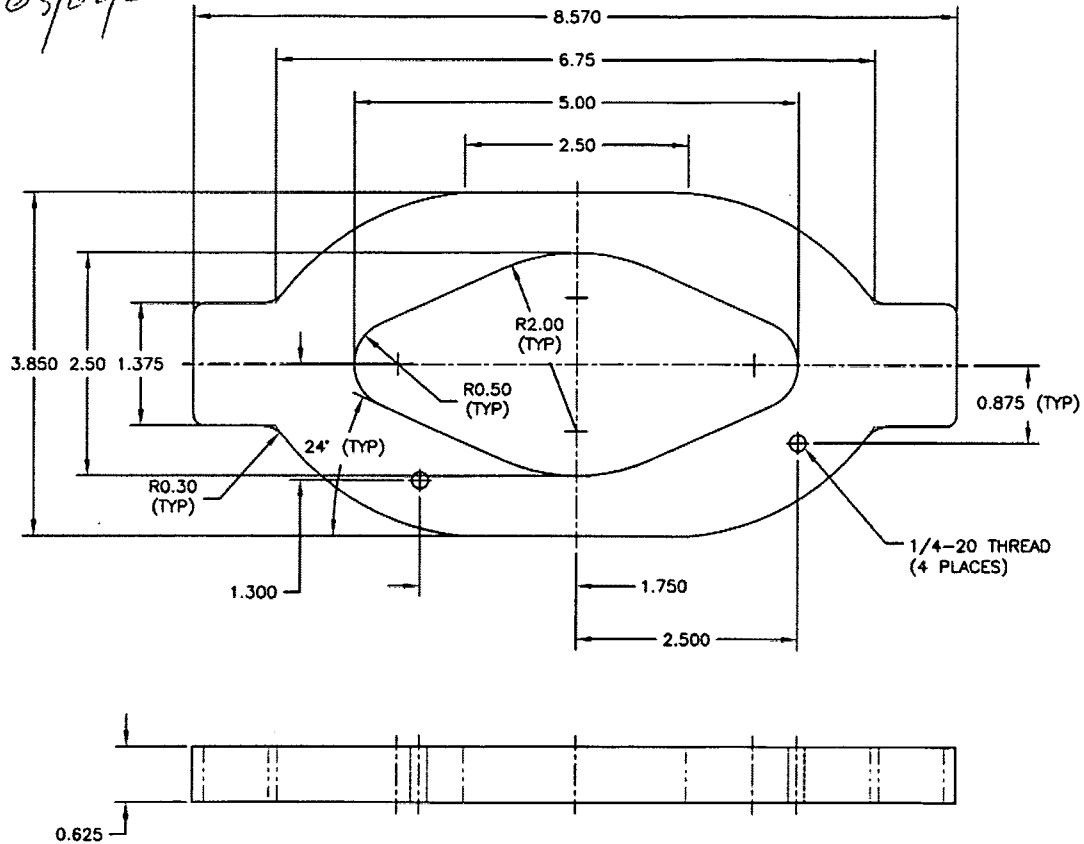
<b>Measured by:</b> J.L.	<b>Audited by:</b> J.B.	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 09/03/09	<b>Date:</b> 09/03/09	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.26	New Issue	KJ/JLM	
B	07.03.21	Dimensions added	KJ/JLM	E

**DART**

DESIGN 74	DRAWN BY 74	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 3	APPROVED [Signature]	DRAWING NO. D3333	REV. B SHEET 1 OF 3
DATE 05.02.18		TITLE PLATE	SCALE 1:2
A	04.12.14	NEW ISSUE	
B	05.02.18	RE-DESIGN D3333-3	

RELEASED  
[Signature]  
05/02/22



### D3333-1 BASE PLATE PANEL

#### NOTES:

- 1) MATERIAL: AISI 4140 STEEL 0.625 THICK STEEL (REF. DART SPEC. M4140-B) MIN. YIELD TENSILE STRENGTH = 100 ksi
- 2) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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WITHOUT NOTICE

WORK ORDER

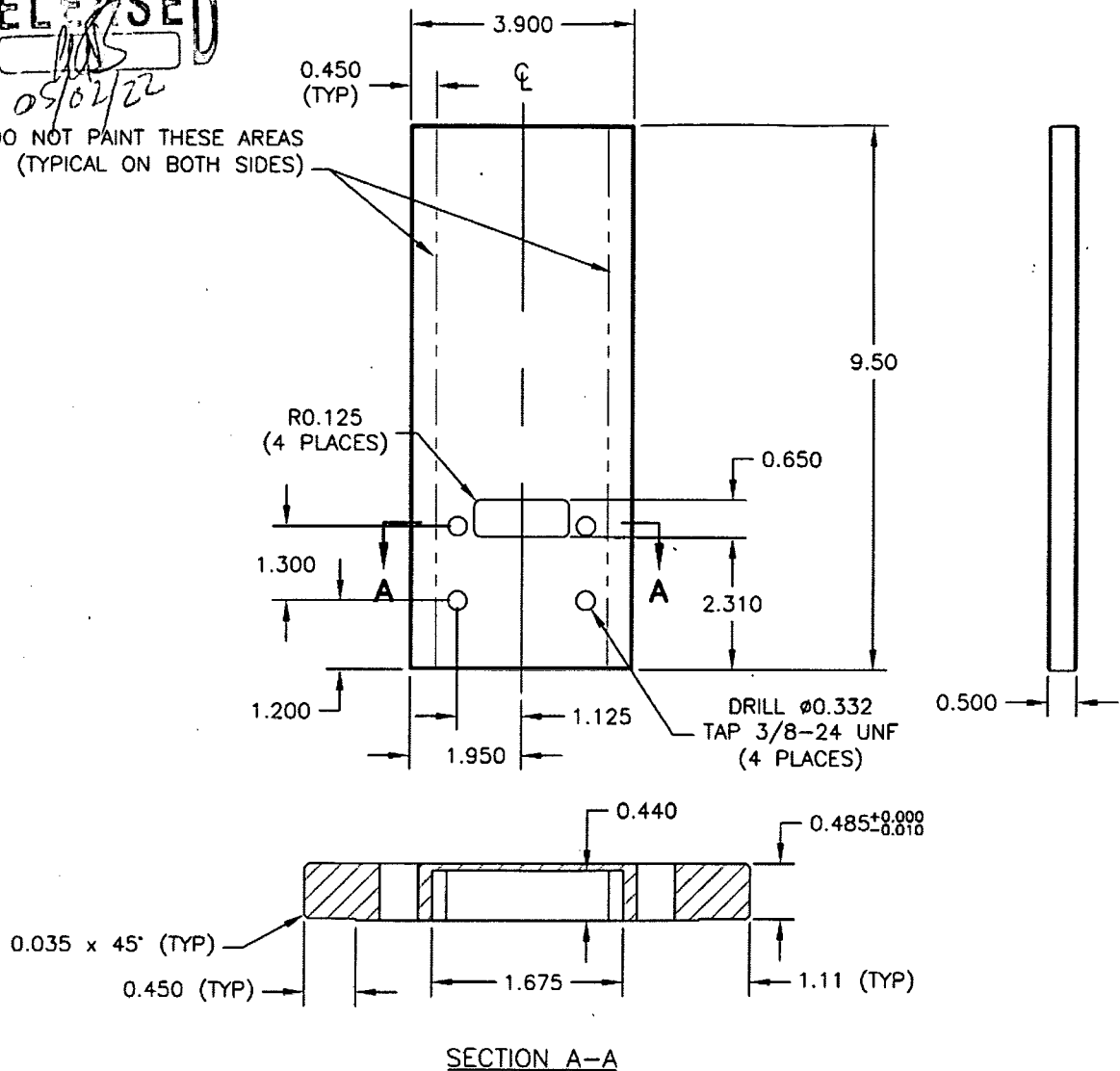
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**DART**

DESIGN H	DRAWN BY H	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 3	APPROVED [Signature]	DRAWING NO. D3333	REV. B SHEET 2 OF 3
DATE 05.02.18		TITLE PLATE	SCALE 1:4

**RELEASED**  
05/02/22DO NOT PAINT THESE AREAS  
(TYPICAL ON BOTH SIDES)**D3333-3 SLIDING PLATE****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570, 0.50 THICK MILD STEEL (REF. DART SPEC. M1010-B)
- 2) FINISH: POWDER COAT FIRE RED (REF. 4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

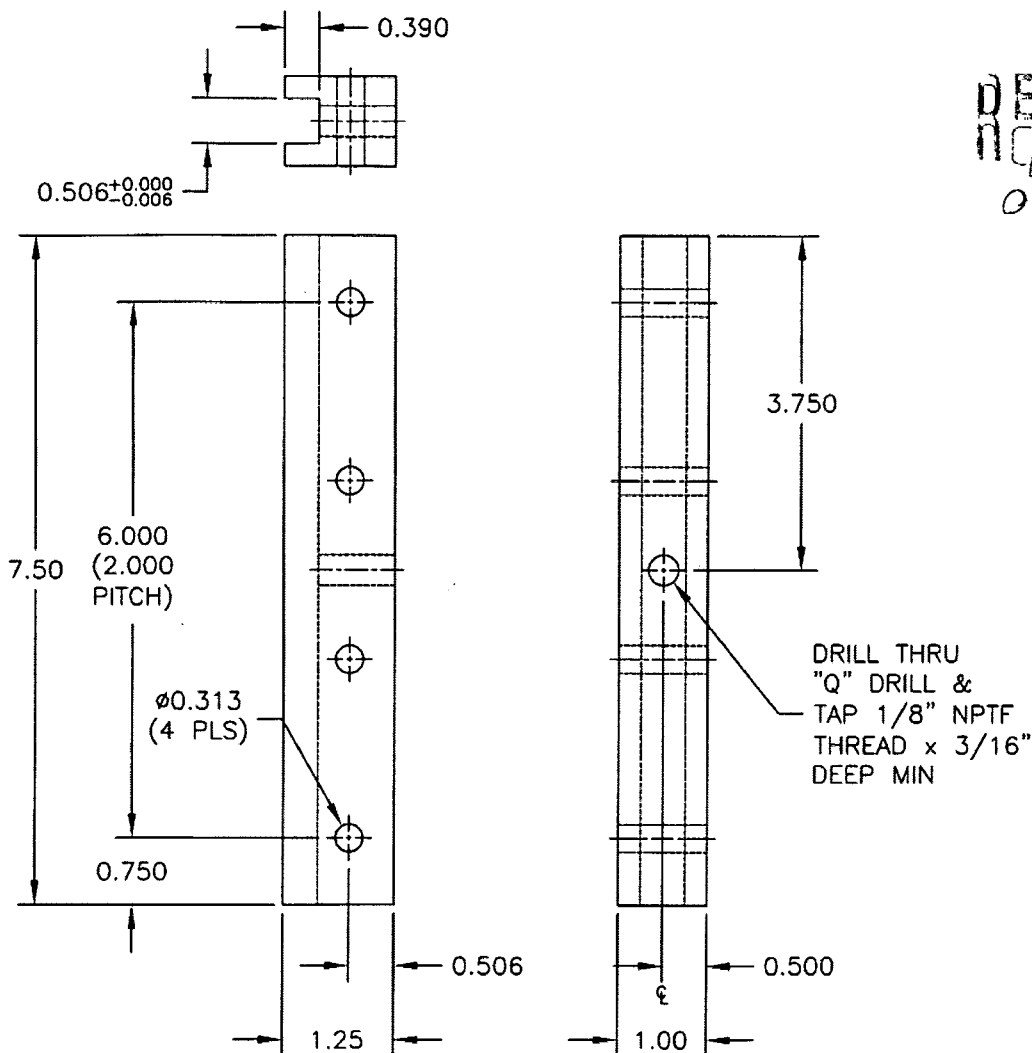
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DESIGN JH	DRAWN BY JH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED JH	APPROVED JH	DRAWING NO. D3333	REV. B SHEET 3 OF 3
DATE 05.02.18	TITLE PLATE		SCALE 1:2



RELEASED  
05/02/22

### D3333-5 RAIL

#### NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570, 1.00 THICK STEEL (REF. DART SPEC. M1010-B)
- 2) FINISH: POWDER COAT FIRE RED (REF. 4.3.5.10) PER DART QSI 005 4.3 WORK ORDER
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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